

Work Order ID 79052

79052

Page 1

January-19-12 9:28:43 AM

Item ID: D3499-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Plate

Start Date: 19/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/01/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3499

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3499

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

6061 . 128

6 0 Jm 12-6-15

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-15

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sidacris

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79052

January-19-12 9:28:43 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

0.00

0.00

0.00

0.00

140

140

Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3499

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

W/O:		WORK ORDER CHANGES					
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79052

January-19-12 9:28:43 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

160

HandFinish

Hand Finishing

Memo

0.00

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

180

OC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 79052

79052

Page 4

January-19-12 9:28:43 AM

Item ID: D3499-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Plate
 Start Date: 19/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
190									
Packaging	Memo	0.00				<u>#26</u>			<u>12/06/29 JB</u>
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							<u>12/17/3 JB</u>
Quality Control									

MCS 12/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-19-12 9:28:47 AM

Page 1

Work Order ID: 79052

79052

Parent Item: D3499-2

D3499-2

Parent Item Name: Mounting Plate

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev: A New Issue 06-05-05 JLM

IPP Rev: B As per Rev B 06-08-31 JLM

IPP Rev: C as per dwg

revC DD 10.02.23 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

124.6400

1.068

6.745263

M6061T6S 125

**

6061-T6 .125 Sheet

Jm 12-6-15

Location

Loc Qty

Loc Code

MAT021

124.64

113608

53.85

118217

6.99

119513

15.8

120218

48

121473

121473

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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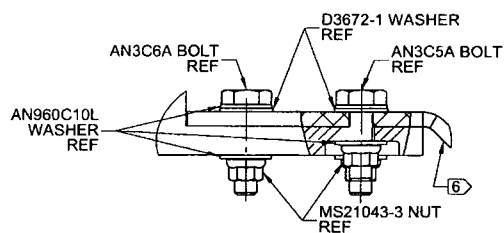
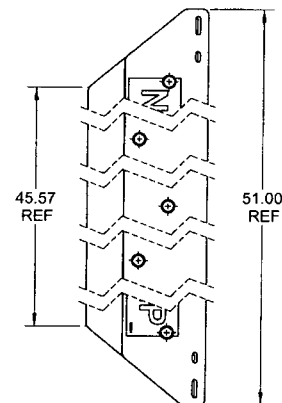
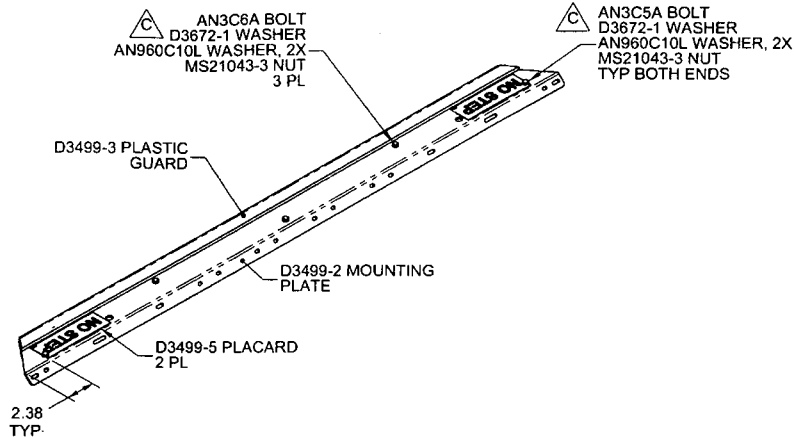
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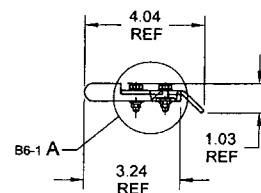
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DETAIL A
B4-1
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.90 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3499-042	CABLE GUARD ASSEMBLY
2	1	D3499-2	MOUNTING PLATE
3	1	D3499-3	PLASTIC GUARD
4	2	D3499-5	PLACARD
5	2	AN3C5A	BOLT
6	3	AN3C6A	BOLT
7	10	AN960C10L	WASHER
8	5	MS21043-3	NUT
9	5	D3672-1	WASHER

79052 H.C.J
12/01/19


RELEASED
2010-02-02
MD

C	DRAWING UPDATED TO CURRENT STANDARDS. 3.245 WAS 3.256 (ZN D3-3); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A8-1); REF NCR-09-045	RF	09.06.19
B	RE-DESIGN D3499-2F/-3	MB	06.08.15
A	NEW ISSUE	MB	06.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	R.F.		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.19		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3499
TITLE CABLE GUARD
REV. C
SHEET 1 OF 4
SCALE NTS

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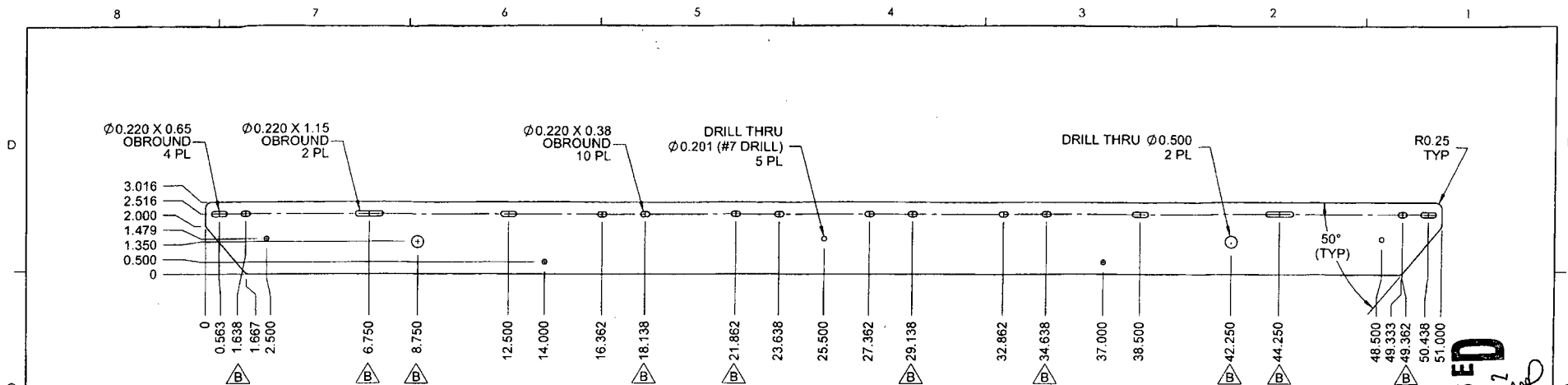
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

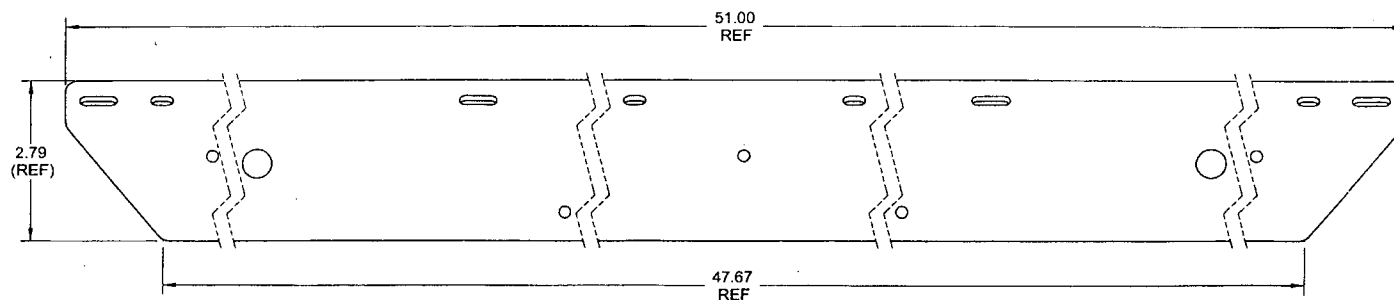
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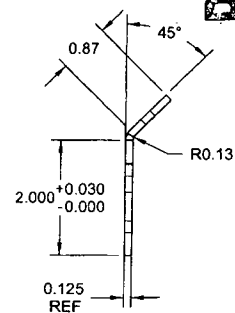
79052



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	B	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 2 OF 4
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R 2010-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

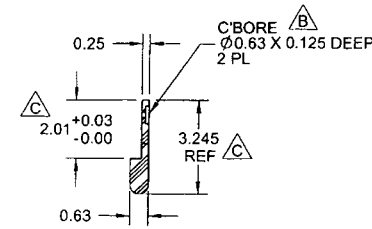
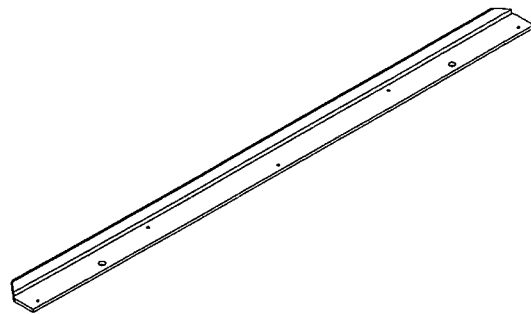
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

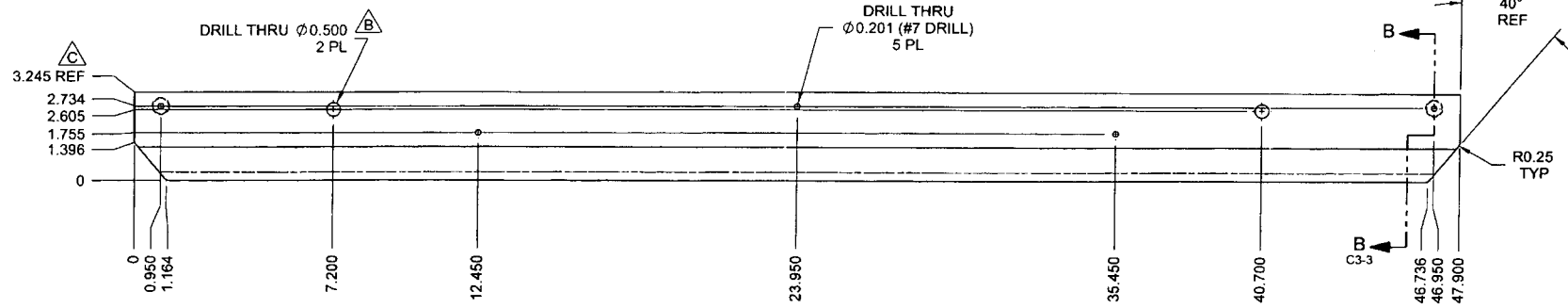
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79052



SECTION B-B B2-3



D3499-3 CABLE GUARD

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.52 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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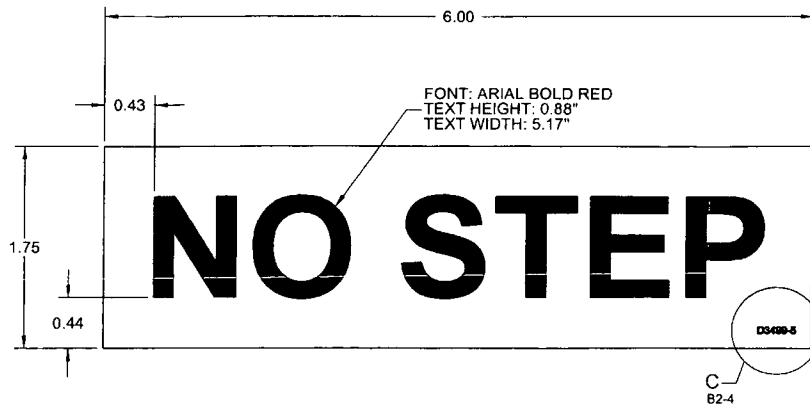
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

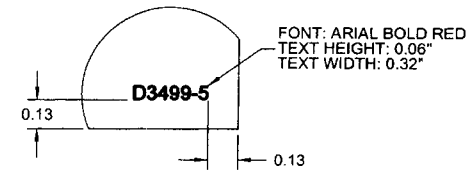
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79052



D3499-5 PLACARD



DETAIL C B5-4
SCALE 2X

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2010-02-03

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
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